

Work Order ID 142195

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142195

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Item ID: D206-628-012

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Item Name: Heli-Access-Step™ RH - High Gear 206A/B

Stop ***NS2***

Start Date: 3/4/2016 Start Qty: 4.00 ***4***

Cust Item ID:

Required Date: 3/25/2016 Req'd Qty: 4.00 ***4***

Customer:

Reference:

Approvals: Process Plan: SU Date: 20160302 Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start ***NR1***
Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
N/A	Rev N/A								
100	Document Control	0.00							
100	DOCUMENT CONTROL								
DC	Memo	0.00							
Doc.Control -USB or Paperwork	Photocopy blue file and type labels as per PPP D206-628-012 CHG 003								
110	Pick Kit	0.00							
110									
Packaging	Memo	0.00							
Packaging									
120	QC4- 100% Inspect kits for completeness	0.00							
120									
QC	Memo	0.00							
Quality Control									

MW 1603-21

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APR 08 2016

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MAR 21 2016

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APR 08 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					

Root Cause			FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐	
OTHER : ☐						

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Item ID: D206-628-012 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Heli-Access-Step™ RH - High Gear 206A/B
 Start Date: 3/4/2016 Start Qty: 4.00 ***4*** Cust Item ID:
 Required Date: 3/25/2016 Req'd Qty: 4.00 ***4*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Packaging	0.00							
130									
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPP D206-628-012 Location : FG081								
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.01							
Quality Control									

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MCS APR 11 2016

MCS APR 11 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval	

Root Cause				FAULT CATEGORY			
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐		
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐		
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐		
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐		
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐		
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐		
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐		
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐		
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐		
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐		
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : ☐					
Misidentified ☐	Past Due ☐						

Picklist Print

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Parent Item: D206-628-012

D206-628-012

Parent Item Name: Heli-Access-Step™ RH - High Gear 206A/B

Start Date: 3/4/2016

Required Date: 3/25/2016

Start Qty: 4.00

Required Qty: 4.00

Comments:

IPP Rev:D As Per Ecn 766 06-01-06 JLM
 IPP rev E changed D2731-1 to D2731-3 EC
 IPP Rev:F as per ecn 1118 08-02-05 DD verified by:

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2721-042		Manufactured	No			110	Each	0.0000	** 4	4			
D2721-042													
206B Step Assy													
D2731-7		Manufactured	No			110	Each	37.0000	** 4	16			
D2731-7													
Mounting Lug													

BAS
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B142195
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Work Order ID: 142195

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Parent Item: D206-628-012

D206-628-012

Parent Item Name: Heli-Access-Step™ RH - High Gear 206A/B

Start Date: 3/4/2016

Required Date: 3/25/2016

Start Qty: 4.00

Required Qty: 4.00

D3394-043

Manufactured No

110 Each

94.0000

4

16

D3394-043

Lug

**

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Location

Loc Qty

Loc Code

ST528

70

132499

2

134677

6

135954

22

137643

20

138239

20

ST532A

24

140957

24

110 Each

523.0000

4

16

AN4-13A

Purchased No

AN4-13A

Bolt

**

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Location

Loc Qty

Loc Code

FG

20

122808

20

GA

120

m134167

120

over003

350

m134039

50

m134260

300

ST344

33

m133998

33

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Work Order ID: 142195

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Parent Item: D206-628-012

D206-628-012

Parent Item Name: Heli-Access-Step™ RH - High Gear 206A/B

Start Date: 3/4/2016

Required Date: 3/25/2016

Start Qty: 4.00

Required Qty: 4.00

AN4-14A

Purchased No

110 Each

567.0000

4

16

AN4-14A

Bolt

**

Location

Loc Qty

Loc Code

FG

5

122141

5

over003

500

M133998

500

ST344

62

M133316

15

M133769

47

Purchased No

110 Each

335.0000

4

16

AN4-15A

AN4-15A

Bolt

**

Location

Loc Qty

Loc Code

GA

40

120449

40

over003

200

m134370

200

ST343

95

m134055

95

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Work Order ID: 142195

142195

Parent Item: D206-628-012

D206-628-012

Parent Item Name: Heli-Access-Step™ RH - High Gear 206A/B

Start Date: 3/4/2016

Required Date: 3/25/2016

Start Qty: 4.00

Required Qty: 4.00

NAS1149D0463J

Purchased

No

110

Each

4,302.000

12

48

NAS1149D0463J

WASHER

**

Location

Loc Qty

Loc Code

GA

237

M129390

41

M132035

196

ST263

2717

M134039

2717

ST269

1348

M130799

360

M132317

100

M132677

888

Purchased

No

110

Each

2,033.000

12

48

MS21042L4

MS21042L4

Locknut

**

Location

Loc Qty

Loc Code

FP001

37

m133363

37

GA

471

m133769

471

ST303

1428

m134055

1428

ST305

97

m130922

97

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5.1 D206-628-011/-012/-021/-022/-031/-032 REGULAR DART HELI-ACCESS- STEPS™ PARTS LIST

Qty -011	Qty -012	Qty -021	Qty -022	Qty -031	Qty -032	Part Number	Description
X						D206-628-011	206 A/B STEP INSTALLATION LH
	X					D206-628-012	206 A/B STEP INSTALLATION RH
		X				D206-628-021	206 L/L1/L3/L4 STEP INSTALLATION LH
			X			D206-628-022	206 L/L1/L3/L4 STEP INSTALLATION RH
				X		D206-628-031	407 STEP INSTALLATION LH
					X	D206-628-032	407 STEP INSTALLATION RH
1						D2721-041	STEP ASSEMBLY LH
	1					D2721-042	STEP ASSEMBLY RH
		1		1		D2724-041	STEP ASSEMBLY LH
			1		1	D2724-042	STEP ASSEMBLY RH
				4	4	D2731-3	MOUNTING LUG
4	4	4	4			D2731-7	MOUNTING LUG
8	8	8	8	8	8	D2732-030	RUBBER CUSHION
				4	4	D3394-041	MOUNTING LUG
				4	4	D3394-1	MOUNTING LUG
				8	8	MS35489-93	GROMMET
4	4	4	4			D3394-043	MOUNTING LUG
4	4	4	4			D3394-3	MOUNTING LUG
8	8	8	8			MS35489-93	GROMMET
4	4			4	4	AN4-13A	BOLT
4	4	4	4	4	4	AN4-14A	BOLT
4	4	8	8	4	4	AN4-15A	BOLT
12	12	12	12	12	12	NAS1149D0463J	WASHER (AN960JD416)
12	12	12	12	12	12	MS21042L4	NUT (OR MS21042-4)

*DENOTES THAT PART IS INCLUDED IN ASSEMBLY ABOVE